

Work Order ID 141820

February 16, 2016 2:27:01 PM

647.3804
B 141820
REV. N/C

141820

Page 1

Item ID: 647.3804

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lower Cutter Assy High

Start Date: 2/16/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 2/19/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: SA Date: 20160216 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
647.3800	n/c

110	Pick Kit	0.00
-----	----------	------

110

Packaging

Memo

0.00

Packaging

5x _____ 16/02/18 ^{DAS 36 9-89}

120

0.00

120

Small Fab

Memo

0.03

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: M133463, M133588
exp. date: 07/17

5x _____ 16/02/18 ^{DAS 36 9-89}

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

(5) _____ ^{DAS 38 9-89}
FEB 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

Work Order ID 141820***141820***

Page 2

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Item ID: 647.3804 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lower Cutter Assy High
Start Date: 2/16/2016 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 2/19/2016 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>CC/KOZ</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER IAW MPP-120***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.01							
Quality Control									

J **DAS** **6** **9-89** **FEB 2 5 2016**

MCJ **FEB 2 5 2016**

MCJ **FEB 2 5 2016**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Picklist Print

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Page 1

Work Order ID: 141820

141820

Parent Item: 647.3804

647 3804

Parent Item Name: Lower Cutter Assy High

Start Date: 2/16/2016

Required Date: 2/19/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 12.10.25 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701 *646 9701* Cutter Sub Assembly		Manufactured	No			110	Each	1.0000	1	5			DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				cck012				1					
					127684			1					
NAS1149FN832P *NAS1149FN832P* Washer		Purchased	No			110	Each	2,947.000	6	30			DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				1529					
					M133316			16					
					M133769			1513					
				ST262				1418					
					M133709			1418					
MS21042L08 *MS21042L 08* Nut		Purchased	No			110	Each	1,698.000	3	15			DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CA				101					
					m129682			101					
				GA				245					
					m133134			3					
					m134063			242					
				OVER007				500					
					m134063			500					
				ST303				852					
					m133922			852					

16/02/16
B141799
5x
16/02/16
16/02/16

30
15

Picklist Print

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Page 2

Work Order ID: 141820

Parent Item: 647.3804

Parent Item Name: Lower Cutter Assy High

141820

647 3804

Start Date: 2/16/2016

Required Date: 2/19/2016

Start Qty: 5.00

Required Qty: 5.00

MS27039-08-19

Purchased

No

110

Each

1,027.000

3

15

MS27039-08-19

Screw

DAS
36
9-89
16/02/16

Location

Loc Qty

Loc Code

CCK06

200

m134142

200

GA

106

m132930

84

m133077

22

over006

638

m133483

38

m134063

600

ST277

83

m133769

83

15

647.3902

Manufactured

No

110

Each

6.0000

1

5

647 3902

Lower Deflector Assembly, High

DAS
36
9-89
16/02/16

Location

Loc Qty

Loc Code

cck052

6

124694

6

5

* 601.2045

1133588

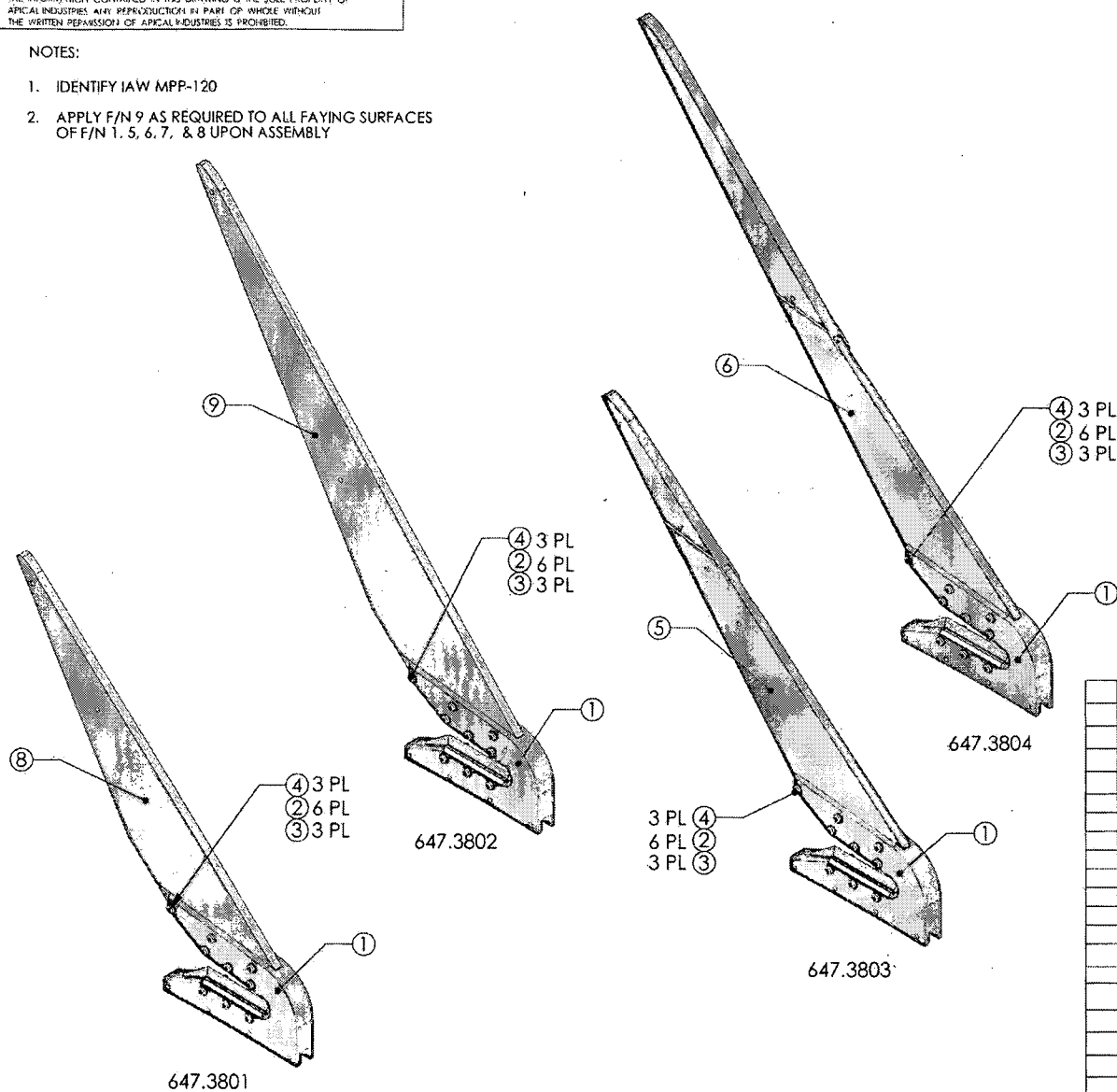
(1x)

DAS
36
9-89

NOTES:

1. IDENTIFY IAW MPP-120
2. APPLY F/N 9 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 5, 6, 7, & 8 UPON ASSEMBLY

REVISIONS			
REV.	DESCRIPTION	DATE	APPROV.
	LAST PROTOTYPE REVISION: PPT		JHC
JHC	FINAL RELEASE	20/08/99	H. GRAV



20160216

SA 14182C

[illegible]